



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-1
Job Sheet 170931



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Part No: D3296-1

Job Qty: 4 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 2/7/18

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/6/18	0.00	0.00	Start Up Waterjet		SC 18/02/06
100	Waterjet	4 pcs		2/6/18	0.03	0.41	Waterjet1		SC 18/02/06
120	QC	4 pcs		2/6/18	0.00	0.00	QC8		38
140	HandFinish	4 pcs		2/7/18	0.00	0.21	HandFinish1		2018/02/12 JSL
150	QC	4 pcs		2/7/18	0.00	0.00	QC7-2		
160	Packaging	4 pcs		2/7/18	0.00	0.00	Packaging3	5.494	DAS 6 FEB 13 2018
170	QC21-SA	4 Ea		2/7/18	0.00	0.00	QC21	9.99	DAS 21 FEB 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	2.6384 sf (.6596 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	3	185	0
	M138389	3		

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches ± 0.030	5.110 5.050	5,086	
2	Door Panel	0.060inches ± 0.030	0.090 0.030	0,060	
3	Door Panel	0.300inches ± 0.010	0.310 0.290	0,301	
4	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128	0,130	
5	Door Panel	16.400inches ± 0.005	16.405 16.395	16,400	
6	Door Panel	0.300inches ± 0.010	0.310 0.290	0,301	
7	Door Panel	13.400inches + 0.005 - 0.030	13.405 13.370	13,400	
8	Door Panel	17.000inches ± 0.030	17.030	17,000	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Desc _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Thermoforming ☐ Finishing ☐ Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐	 S040485 Door Panel Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com PART NO: D3296 – 1 Original Serial #: S040485 Revision: Operation: Start up Operation Change No: 02/08/18 Job No: 170931																																																			
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Environment</td> <td style="width:5%;">☐</td> <td style="width:15%;">No</td> <td style="width:5%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Op</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Off</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> </table>		Environment	☐	No	☐	Design	☐	Op	☐	Doc/Data	☐	Off	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter </td> <td style="width:33%;"> Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes </td> <td style="width:33%;"> Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center </td> </tr> </table>		Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center
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			16.970	
9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150	14,182
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,300
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053	0,063 0,062

Plex 1/24/18 10:20 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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